

Date: Wednesday, 18/02/2009 9:29:47 AM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET BASE ASSEMBLY (350)		
Job Number	: 45848A	Part Number	: D2221		
Estimate Number	: 10189	Drawing Number	: D2221 REV H		
P.O. Number	:	Project Number	: N/A		
This Issue	: 18/02/2009	Drawing Revision	: H		
Prsht Rev.	: NC	Material	:		
First Issue	: 18/02/2009	Due Date	: 25/02/2009	Qty:	1 Um: Each
Previous Run	: 45771A				
Written By	:				
Checked & Approved By	: <u>2009.02.18</u>				
Comment	Est Rev:J 05.09.02 Added D3442-1 KJ/JLM Est Rev:K 08-08-29 revG as per dwg DD verified by:EC Est Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC Est Rev:M 08-12-02 revH as per dwg DD verified by:				
Additional Product					
Job Number:					
Seq. #:	Machine Or Operation:	Description :			
1.0	D22211	Rib			
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)			
		Rib			
		batch: <u>B 44864 → 1x</u>			<u>SJ 09/02/23</u>
2.0	D22215	Rib			
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)			
		Rib			
		batch: <u>B 45502 → 2x</u>			<u>SJ 09/02/23</u>
3.0	D22217	Rib			
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)			
		Rib			
		batch: <u>B 44773 → 1x</u>			<u>SJ 09/02/23</u>
4.0	D22323	Basket Hinge			
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)			
		Basket Hinge			
		batch: <u>B 42075 → 2x</u>			<u>SJ 09/02/23</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/02/2009 9:29:47 AM
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Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 45848A

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D22351 Basket Rib



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Rib

batch: B45808 → 2.

SL 09/02/23

6.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

batch: B45800 → 2.

SL 09/02/23

7.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Shim

batch: B45226 → 2.

SL 09/02/23

8.0 D3825041 Rib Assembly (Basket End)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rib Assembly (Basket End)

batch: B45505 → 2.

SL 09/02/23

9.0 D3826041 Rib / Gusset Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rib / Gusset Assembly

batch: B45506 → 2.

SL 09/02/23

10.0 D3827041 Rib Assembly (Inboard)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib Assembly (Inboard)

batch: B344771 → 1.

SL 09/02/23

11.0 D38331 Mesh (Base End Face)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mesh (Base End Face)

batch: B44764 → 2.

SL 09/02/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/02/2009 9:29:48 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 45848A

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 D38321 Mesh (Base)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mesh (Base)

batch: B45610 → 1x

SL 09/02/23

13.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221

2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221

3- tack weld mesh on basket as per dwg D2221

A/R ER316 S.S. Rod Batch: M108725

SL 09/02/24 (X)

14.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

LPC 09-02-25

15.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 09/02/25 (X)

16.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

- ✓ 1- Plug holes prior to powder coating
- ✓ 2-Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME: 7:20 AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 7:50 AM

***** 2nd coat if necessary *****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M 09-02-26 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

17.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

E608/02/26 0

18.0 QC21

FINAL INSPECTION/W/O RELEASE



09/03/02 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF
09-02-07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASER
08/11/18 AD**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 42.00 lbs APPROX
- 8) MASK ALL HOLES PRIOR TO POWDER COATING

SHIPPING COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. W58484

ITEM **QTY** **P/N** **DESCRIPTION**

1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2681	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

H REVISIONS LISTED ON SHEET 5
REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN B6-3, C2-3 AND A3-3); REVISED DETAIL D (ZN B7-1, D2-1, E2-1, F2-1, G2-1, H2-1, I2-1, J2-1, K2-1, L2-1, M2-1, N2-1, O2-1, P2-1, Q2-1, R2-1, S2-1, T2-1, U2-1, V2-1, W2-1, X2-1, Y2-1, Z2-1); REVISED SECTION A-A (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3625-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.

MB 08.09.18

G MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT

AJS 08.06.16

F ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET

PH 05.06.07

E CHANGE HINGE

CP 01.04.19

D CHANGE LATCH

BW 96.06.21

C SEPARATE BASKET AND LID

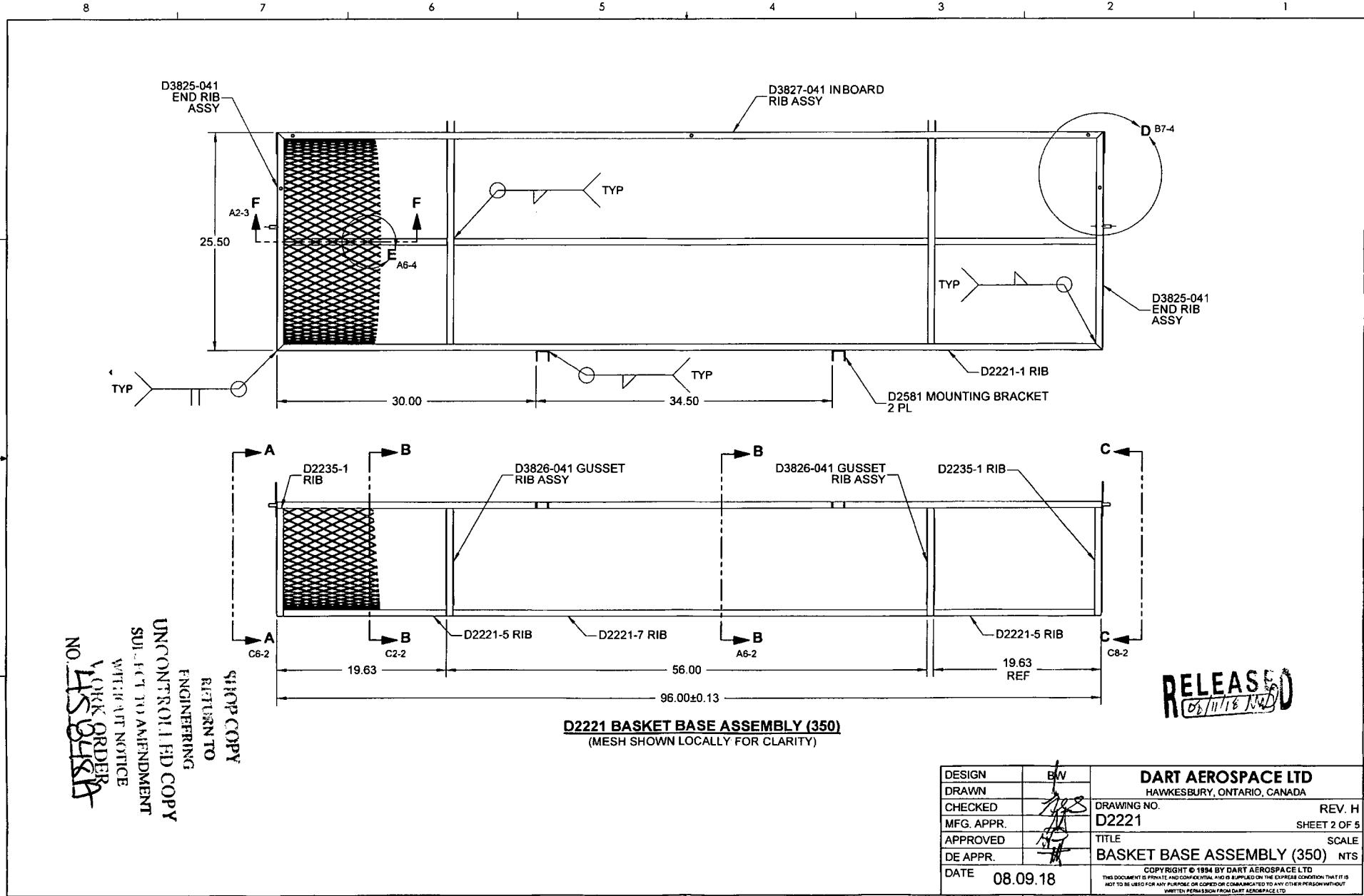
KH 95.11.21

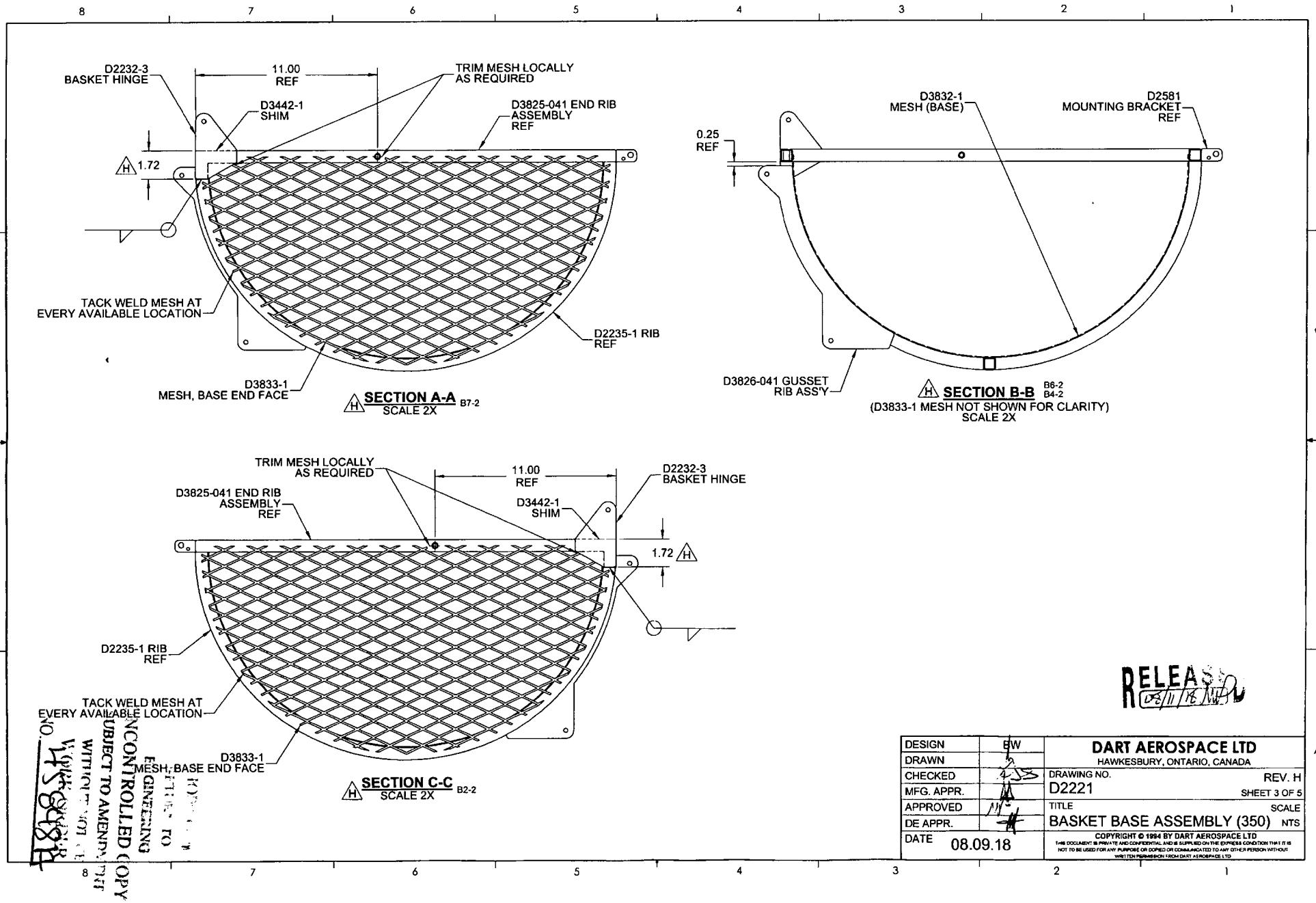
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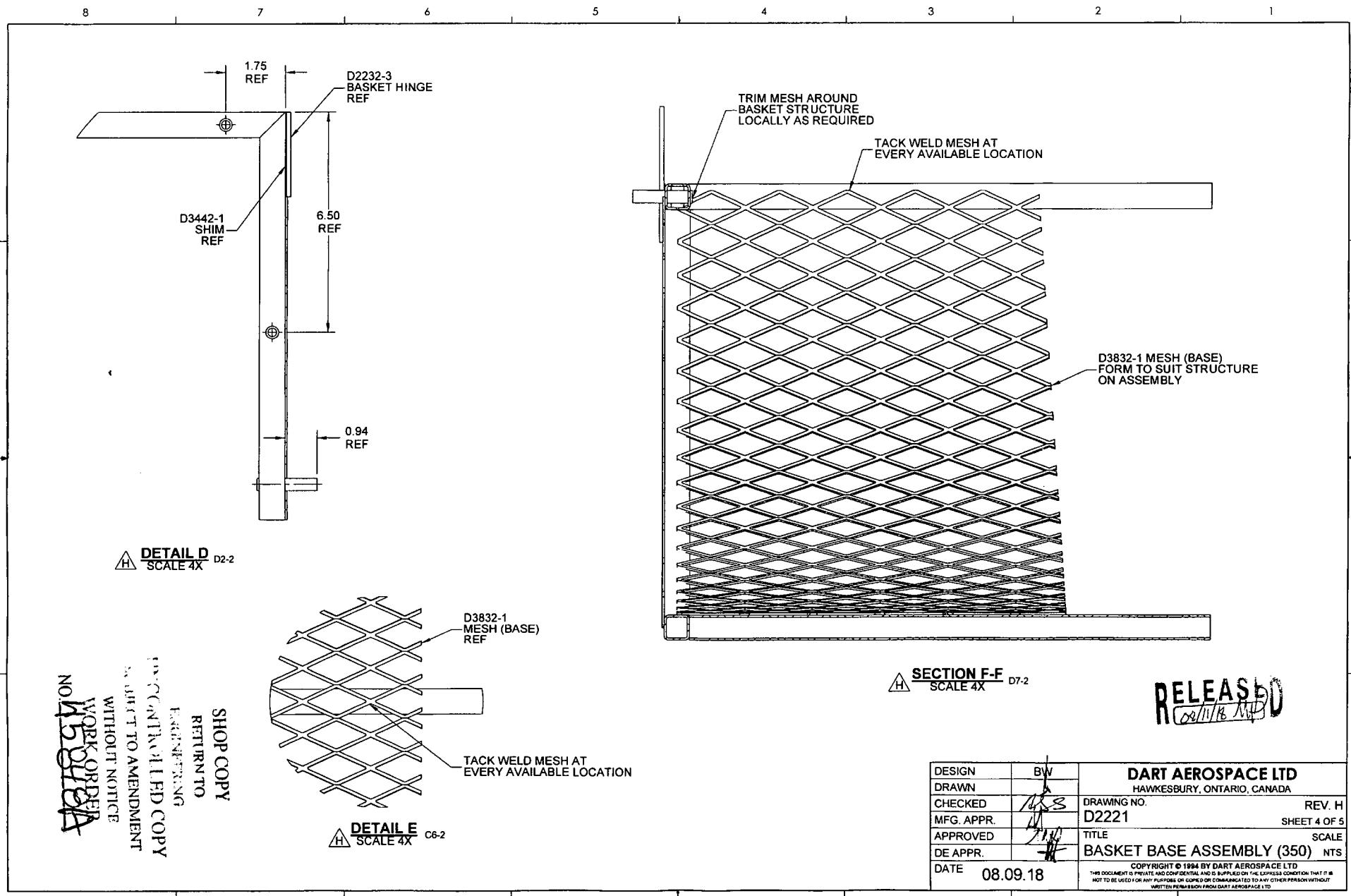
DESIGN **BW** **DART AEROSPACE LTD**
DRAWN **BY** **HAWKSLEY, ONTARIO, CANADA**
CHECKED **MS** **DRAWING NO.**
MFG. APPR. **TP** **REV. H**
APPROVED **TP** **SHEET 1 OF 5**
DE APPR. **TP** **TITLE**
DATE **08.09.18** **SCALE**
BASKET BASE ASSEMBLY (350) **NTS**

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8 7 6 5 4 3 2 1







DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	A	DRAWING NO. D2221
CHECKED	<i>MS</i>	REV. H
MFG. APPR.	<i>MM</i>	SHEET 4 OF 5
APPROVED	<i>MM</i>	TITLE
DE APPR.	<i>MM</i>	SCALE
DATE	08.09.18	BASKET BASE ASSEMBLY (350) NTS

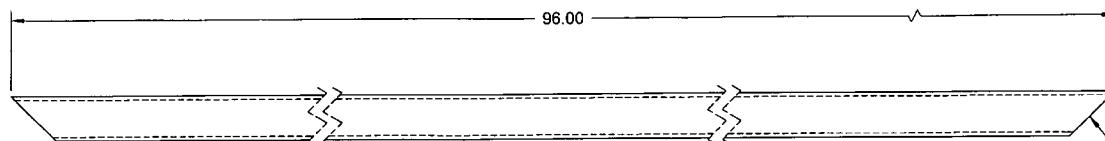
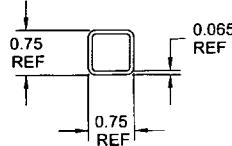
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RELEASED
08/11/18 MHD

8 7 6 5 4 3 2 1

D

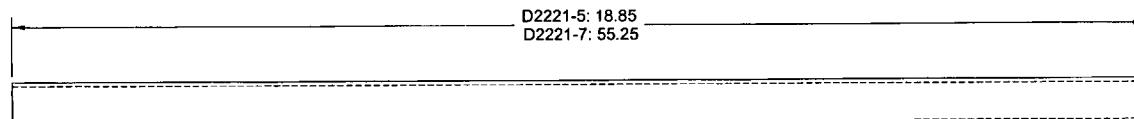
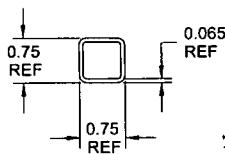
D



⚠ D2221-1 RIB

C

C



⚠ D2221-5-7 RIB

B

B

UNCONTROLLED COPY
STRICT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. **D2221-1**

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT:D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

RELEASED
08/09/18 AM

DESIGN	B/W	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
		D2221	
MFG. APPR.		SHEET 5 OF 5	
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

A

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